

Date: Tuesday, 5/23/2006 8:31:27 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BUSHING
 Job Number : 27189
 Estimate Number : 10680
 P.O. Number : *NIA*
 This Issue : 5/23/2006 S.O. No. : *NIA*
 Prsht Rev. : NC
 First Issue : *NIA* Type : MACHINED PARTS
 Previous Run : 24344
 Written By : *See DOCUMENT Below*
 Checked & Approved By : *OK 06.05.23*
 Comment : Est. A 02.05.27 New Issue NG

Part Number : D31553
 Drawing Number : D3155 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : *NIA*
 Due Date : 6/12/2006 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 SS81220 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick:

Qty Part number Description Batch

1 SS-812-20 Symmco bushing *M101102* *4 taken*

1 Symmco bushing makes 2 parts.

MS 06/06/25

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine to length Folio FA243 → *done manually*

Deburr bushing inside and out.

MS 06/06/26

15

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MS 06/06/26

15

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST410*

AP 06/06/26 (15)

5.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/27 (15)

W 06/06/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 04/06/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

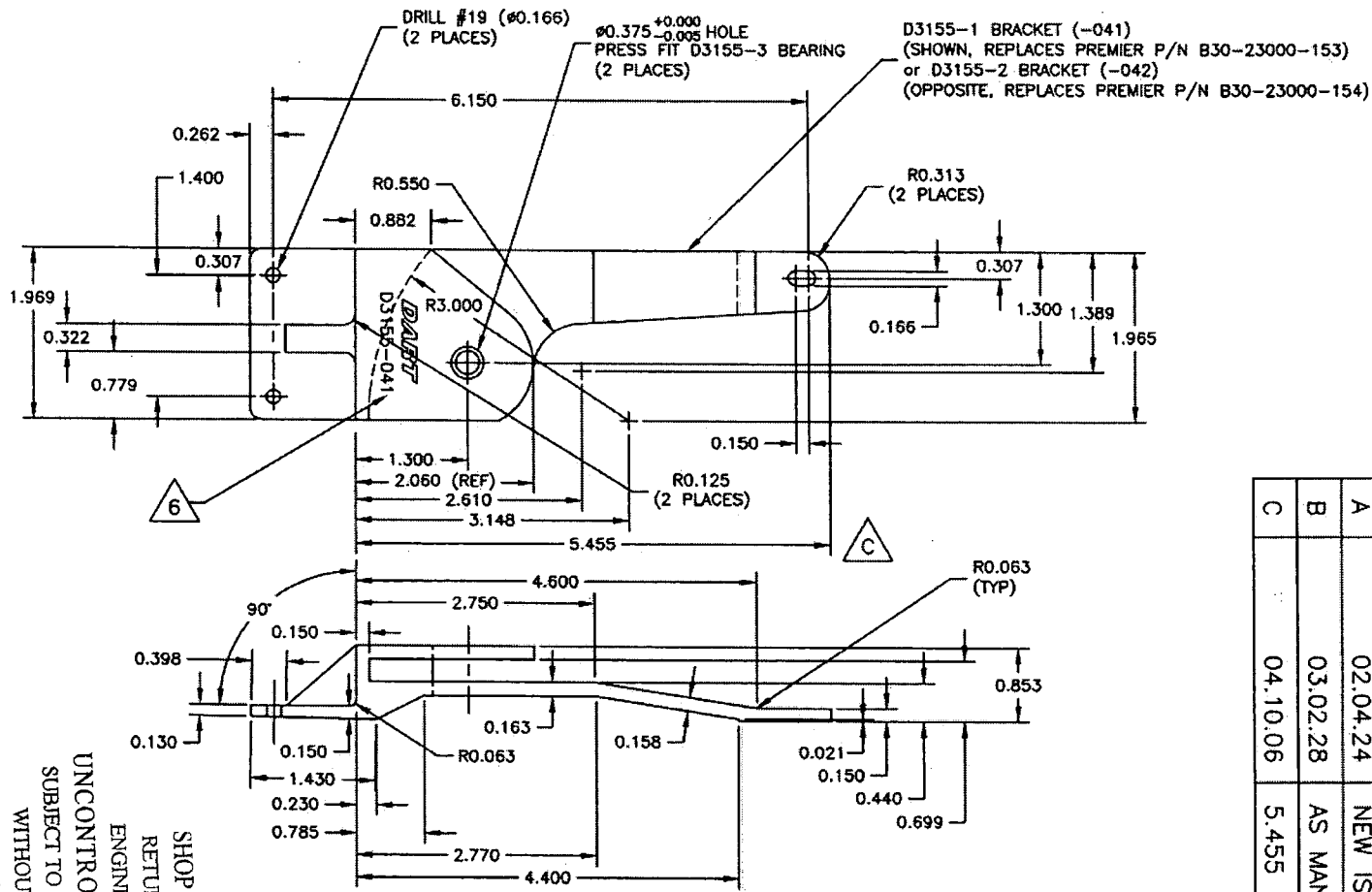
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
04.10.06	D3155	SHEET 1 OF 2
	TITLE	SCALE
	BRACKET ASSEMBLY	1:2
A	02.04.24	NEW ISSUE
B	03.02.28	AS MANUFACTURED
C	04.10.06	5.455 WAS 5.550



D3155-041 BRACKET ASSEMBLY

(SHOWN, REPLACES PREMIER P/N B30-23000-11)

D3155-042 BRACKET ASSEMBLY

(OPPOSITE, REPLACES PREMIER P/N B30-23000-12)

D3155-1/-2 BRACKET

- 1) MATERIAL: 6061-T6/-T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO AS SHOWN

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27189

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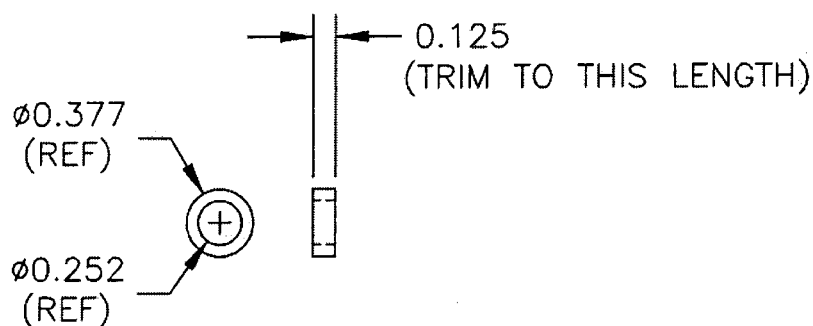
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RELEASED
04.11.23



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3155	REV. C SHEET 2 OF 2
DATE 04.10.06		TITLE BRACKET ASSEMBLY	SCALE 1:1

RELEASED
04.11.23



D3155-3 BUSHING

- 1) MAKE FROM P/N SBS-3-3 (SOLID BAR) OR SS-812-20 (TUBING)
POSSIBLE SUPPLIER: SYMMCO
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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